

Date: Friday, 22/05/2009 8:59:00 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 48113D		
Estimate Number	: 10380		
P.O. Number	:	Part Number	: D30657
This Issue	: 22/05/2009	S.O. No.	: D3065 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 47090D	Material	:
Written By	:	Due Date	: 28/05/2009
Checked & Approved By	: <u>JUL 09-05-25</u>	Qty:	40
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM	Um:	Each
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
Comment:	Qty.: 0.1653 sf(s)/Unit Total : 6.6108 sf(s)		
Material:	2024-T3 (QQ-A-250/4) 0.040" thick		
(M2024T3S.040)	Batch: <u>111381</u> <u>B 9-5-28</u>		
2.0	WATER JET	FLOW WATER JET	
Comment:	FLOW WATER JET		
1-Cut as per Dwg D3065			
Dwg Rev:	<u>B</u>	<u>B 9-5-28</u>	
Prog Rev:	<u>B</u>		
2-Deburr if necessary	<u>B 9-5-28</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK	
Comment:	SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment:	SMALL & MEDIUM FAB RESOURCE 1		
Deburr if necessary.	<u>111381</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 8:59:00 AM
User: Julie Dawson

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Drawing Name: STEP SPACER

Job Number: 48113D

Part Number: D30657

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 09/06/01 (50)
09/05/29 (00)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

(MD 09/06/01) (50)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FZ 09/06/01

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Sylvie

10/06/01 (50)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/02 (50)

Job Completion



MF
09-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	481130
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

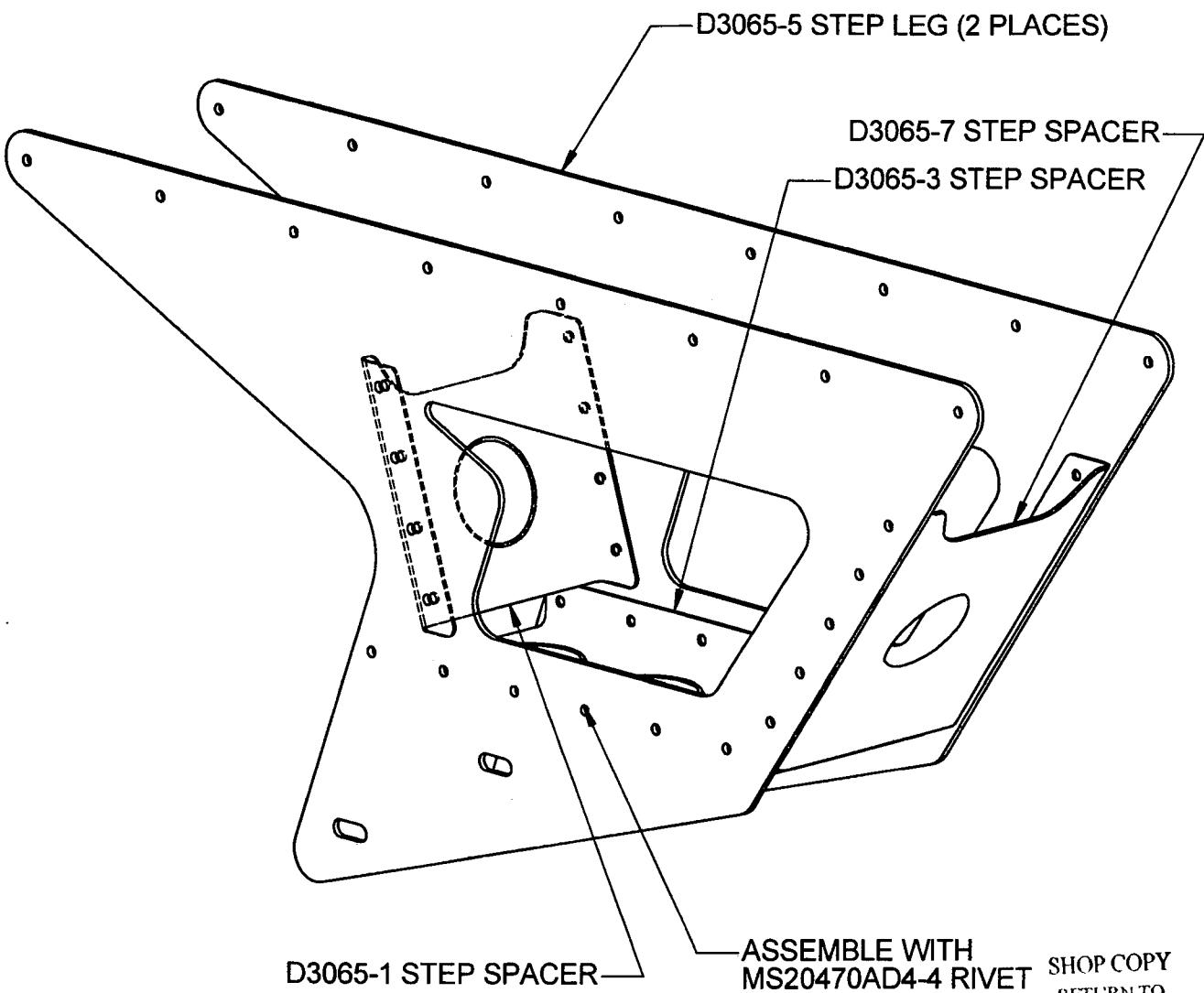
X First Article Prototype

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-5-28	Date: 07/5/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3065	REV. B	SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2	
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

RELEASED*06.06.20 TH***D3065-041 STEP LEG ASSEMBLY**

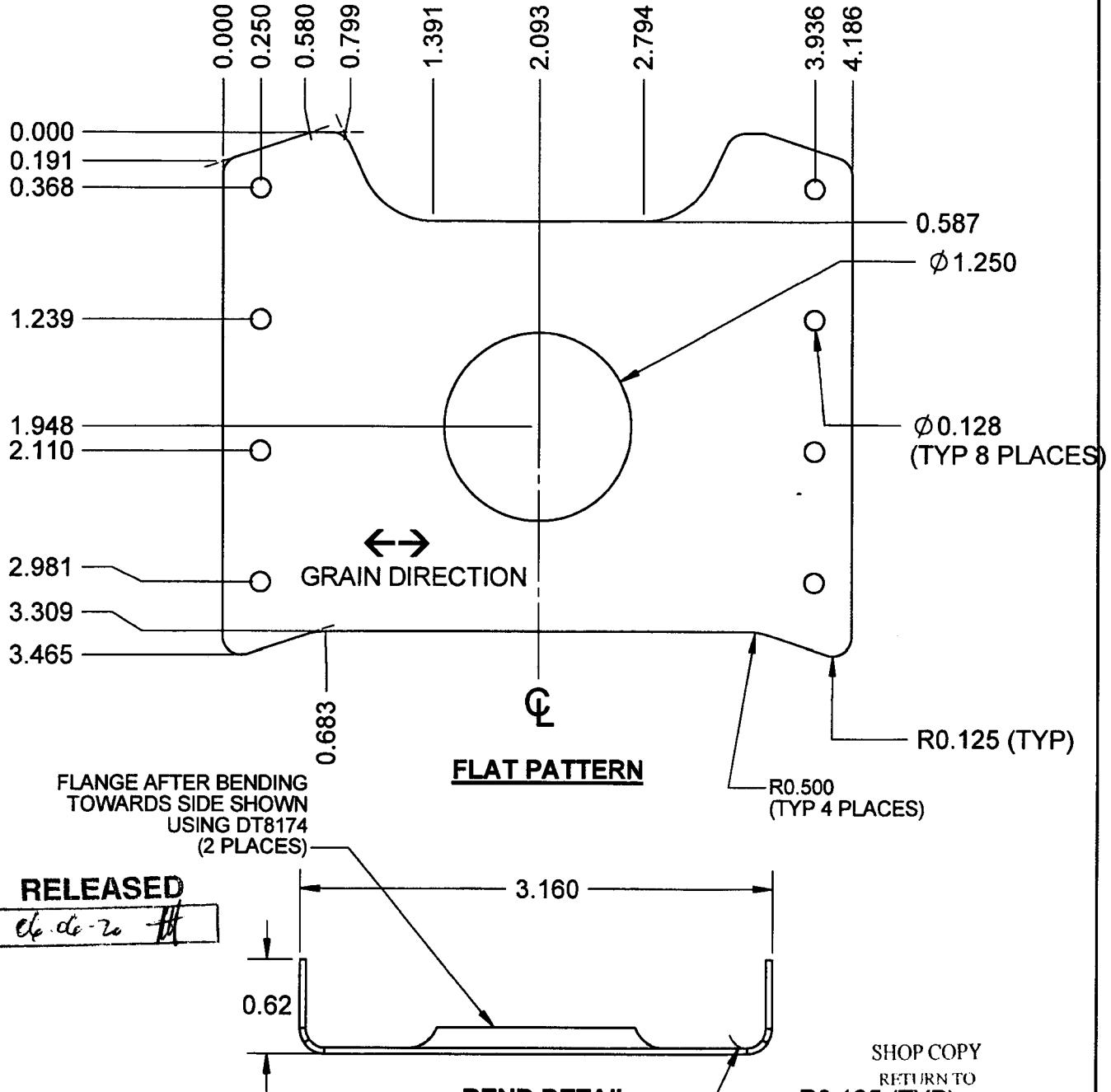
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DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-1 STEP SPACER**

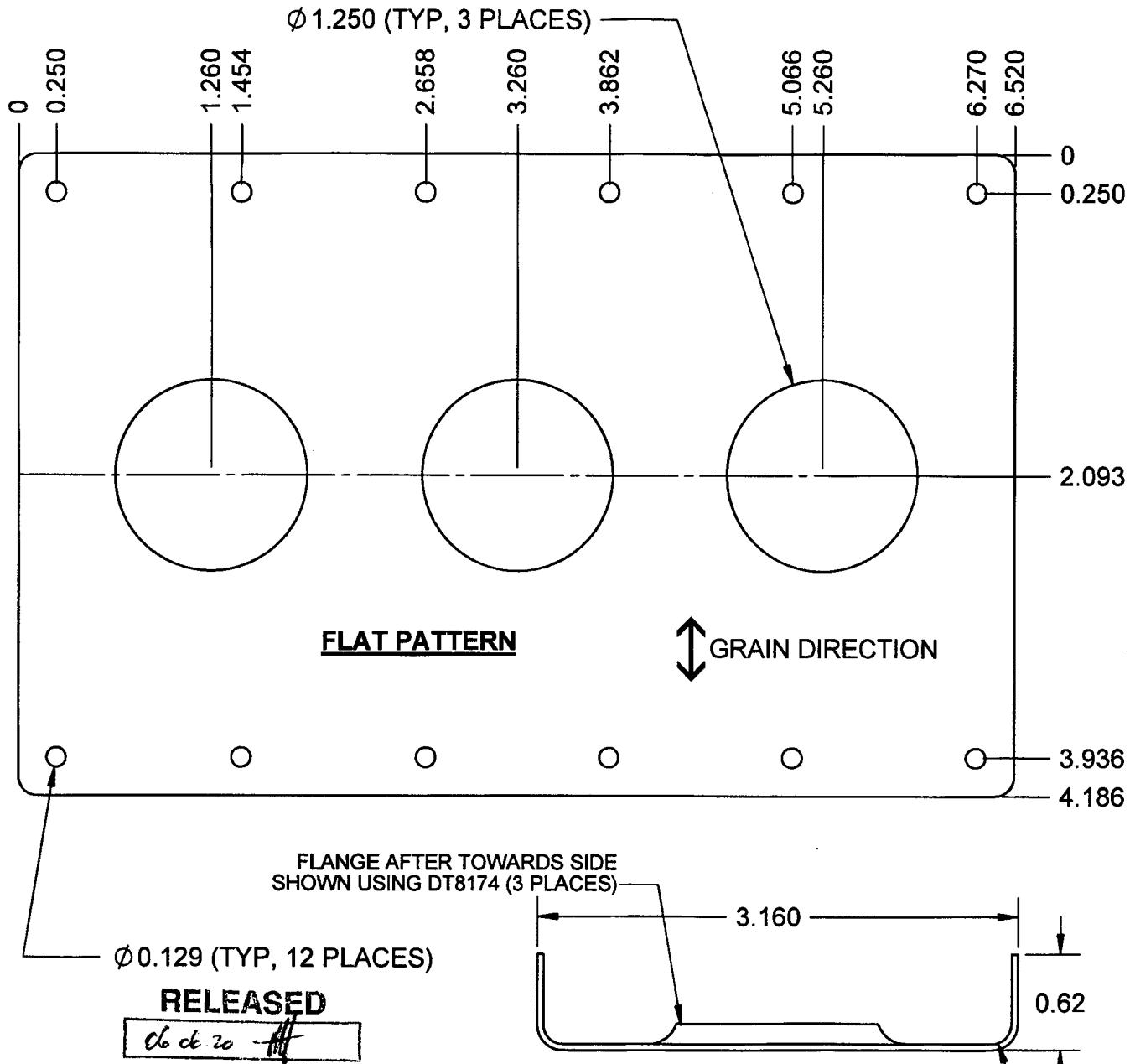
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

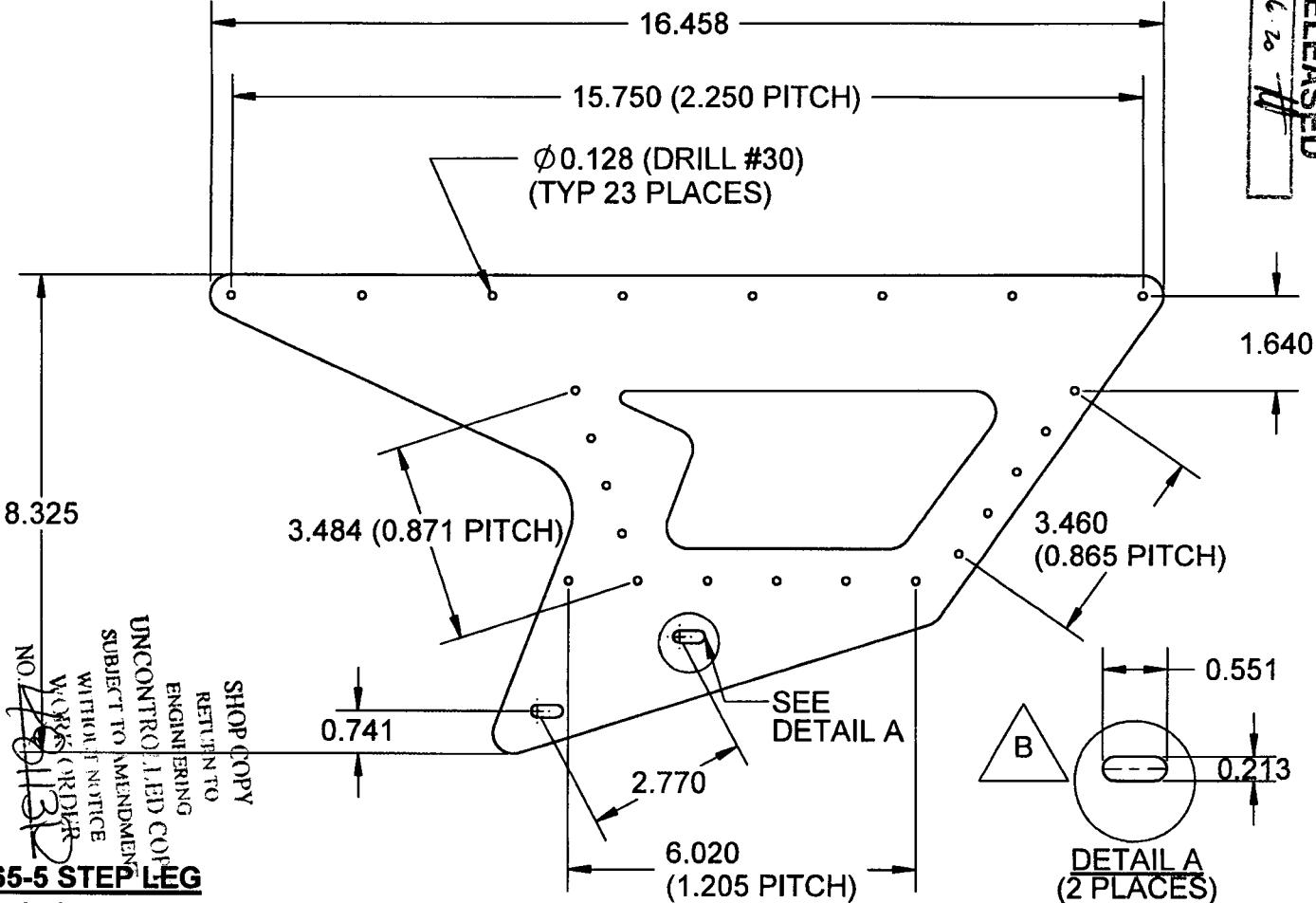
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40	C.B.	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
P.H.	P.H.	D3065
DATE	TITLE	REV. B
06.05.23	STEP LEG ASSEMBLY	SHEET 4 OF 5
		SCALE
		1:3

RELEASED
06.06.06
[Signature]**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

